

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016601**Date Inspected:** 29-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG and Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Larry Viars was present during the times noted above for observations relative to the work being performed.

Bay 14-

This QA Inspector observed the following work in progress: Submerged Arc Welding (SAW) of OBG Segment 13CW side panel weld, SEG3015A-010. ZPMC welder was identified as 045270. ZPMC QC was identified as Xia Chun Hui. ZPMC CWI was identified as Wang Jie. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2221-B-L2c-S-2.

Flux Cored Arc Welding (FCAW) of OBG Segment 13CW bottom panel weld, SEG3015A-007. ZPMC welder was identified as 201215. ZPMC QC was identified as Xia Chun Hui. ZPMC CWI was identified as Wang Xu. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2231-B-U2-F.

Flux Cored Arc Welding (FCAW) of OBG Segment 13CW Corner Assembly weld, CA3016A-168. ZPMC welder was identified as 047866. ZPMC CWI was identified as Wang Jie. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2231-B-U2-F.

Bay 19-

This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) of OBG Suspender

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Bracket SB78W weld, SB016-078-001. ZPMC welder was identified as 062757. ZPMC QC was identified as Xia Chun Hui. ZPMC CWI was identified Xu Tao. The welding appeared to be in conformance with welding procedure specification, WPS-345-FCAW-1G(1F)-Repair.

West of Blast Bay 1-

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG Cross Beam 11 internal upper section base metal and weld surfaces. Areas requiring light grinding were marked for ZPMC personnel. Arc strikes were marked for grinding and Magnetic Particle Testing by ZPMC personnel. Items which require repair were recorded for future repair.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation between QA and QC occurred this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Viars,Larry	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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